

Date: Monday, 2/5/2007 8:08:51 AM  
 User: Kim Johnston

## Process Sheet

|                       |   |                  |               |
|-----------------------|---|------------------|---------------|
| Customer              | : CU-DAR001 Dart Helicopters Services                                       | Drawing Name     | : FITTING     |
| Job Number            | : 30616   |                  |               |
| Estimate Number       | : 10870   |                  |               |
| P.O. Number           | : N/A   | Part Number      | : D32163      |
| This Issue            | : 2/5/2007  | S.O. No.         | : N/A         |
| Prsht Rev.            | : NC  | Drawing Number   | : D3216 REV A |
| First Issue           | : N/A   | Project Number   | : N/A         |
| Previous Run          | : 29141   | Drawing Revision | : A           |
|                       |   | Material         | : N/A         |
|                       |   | Due Date         | : 2/9/2007    |
| Written By            | :   | Qty:             | 20 Um: Each   |
| Checked & Approved By | :   |                  |               |
| Comment               | : Est: A 02.10.28 New Issue KJ/RF<br>Est Rev:B Now on Waterjet 06-07-03 JLM |                  |               |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |           |                    |
|-----|-----------|--------------------|
| 1.0 | M304S11GA | 304/316 .125 Sheet |
|-----|-----------|--------------------|



Comment: Qty.: 0.0302 sf(s)/Unit Total : 0.6048 sf(s)

304/316 .125 Sheet

(M304S0125)

Batch: M102817

MM 07 02 14

(20)

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D3216

Dwg Rev: A

Prog Rev: A

MM 07 02 14

(20)

2-Deburr if necessary

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



(20)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

|     |             |                               |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr if necessary.

Tumble until parts have a polished finish.

07/02-23

07/02/19

FF

MM 20

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DP Date: 07/02/2016  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Monday, 2/5/2007 8:08:51 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 30616

Part Number: D32163

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JB 07/02/23 (20)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 0

07/12/23 (20)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/26 (20)

Job Completion



07.02.26

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

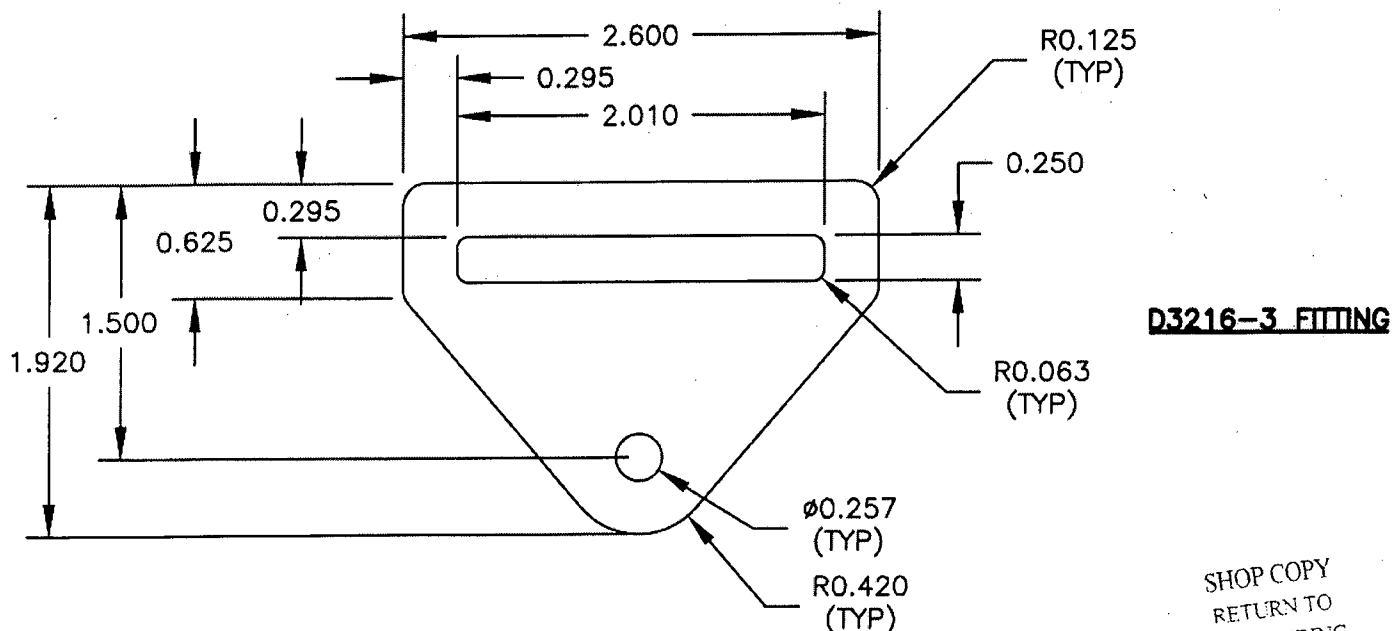
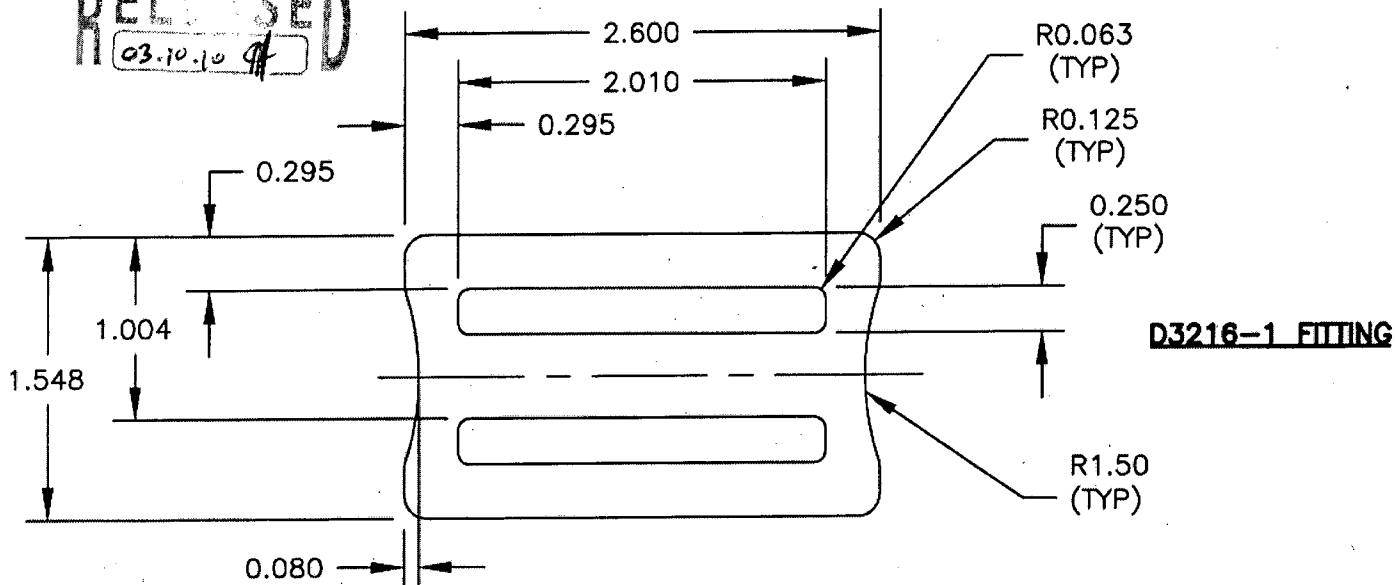
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



|                        |                         |   |                        |
|------------------------|-------------------------|---|------------------------|
| DESIGN<br>CP           | DRAWN BY<br>CP          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>[Signature] | APPROVED<br>[Signature] | DRAWING NO.<br>D3216                              | REV. A<br>SHEET 1 OF 1 |
| DATE<br>03.09.26       |                         | TITLE<br>FITTING                                  | SCALE<br>1:1           |
| A                      | 03.09.26                | NEW ISSUE   |                        |

RELEASED  
03.10.10 [Signature]



**D3216-1/-3 FITTING**

- 1) MATERIAL: AISI 304/316 PLATE, 0.125 THICK (REF DART SPEC. M304S110A)
- 2) FINISH: MOLECRO POLISH
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30616

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# FIRST ARTICLE INSPECTION CHECKLIST

**X**


## First Article


**X**

## Prototype

[illegible]

|              |               |
|--------------|---------------|
| Measured by: | <i>ml. ml</i> |
| Date:        | <i>070214</i> |

|                    |   |
|--------------------|---|
| <b>Audited by:</b> |  |
| <b>Date:</b>       | 07.02.14  |

|                     |   |
|---------------------|---|
| Prototype Approval: |  |
| Date:               |   |

|     |      |           |            |          |
|-----|------|-----------|------------|----------|
| Rev | Date | Change    | Revised by | Approved |
| A   |      | New Issue | KJ/JLM     |          |